# Work Order ID 109332

*November-19-13 12:38:43 PM*

*109332*



**Item ID:** D4785-5 **Accept** *N900040100* **Setup Start** *NS1*

**Revision ID:**

**Item Name:** Rib **Stop** *NS2*

**Start Date:** 11/19/13 **Start Qty:** 2.00 *2*

**Required Date:** 12/03/13 **Req'd Qty:** 2.00 *2*

**Reference:**

**Cust Item ID:**

**Customer:**

**Approvals:** **Process Plan:** ML5 **Date:** 13-11-19 **Tooling:** _____ **Date:** _____ **Run Start** *NR1*

**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| Draw Nbr: D4785 / Revision Nbr: B | | | | | | | | | |
| 100 | | 0.00 | | | | | | | |
| *100* | | | | | | | | | |
| Large Fab | **Memo** | 0.00 | | | | | | | |
| Large Fab | 1- Cut tube as per dwg D4785<br>2- remove identification marks and deburr | | | | | (2x) CC 13-11-19 | | | |
| 110 | QC6- Inspect dimensions to drawing | 0.00 | | | | | | | |
| *110* | | | | | | | | | |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | | | | | | 2x DAS 43 13-11-19 | | | |
| 120 | Identify as per dwg & Stock Location: W/A 004 | 0.00 | | | | | | | |
| *120* | | | | | | | | | |
| Packaging | **Memo** | 0.00 | | | | | | | |
| Packaging | | | | | | 2x CC 13-11-19 | | | |

# Work Order ID 109332

*November-19-13 12:38:44 PM*

*109332*

**Item ID:** D4785-5 **Accept** *N900040100* **Setup Start** *NS1*

**Revision ID:** **Stop** *NS2*

**Item Name:** Rib

**Start Date:** 11/19/13 **Start Qty:** 2.00 *2* **Cust Item ID:**

**Required Date:** 12/03/13 **Req'd Qty:** 2.00 *2* **Customer:**

**Reference:**

**Run Start** *NR1*

**Stop** *NR2*

**Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 130 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | 13/11/21 | | |
| *130* | | | | | | | | | |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

WMF 13-11-20

# Picklist Print

*November-19-13 12:38:47 PM*



**Work Order ID:** 109332 *109332*

**Parent Item:** D4785-5 *D4785-5*

**Parent Item Name:** Rib

**Start Date:** 11/19/13 **Required Date:** 12/03/13

**Start Qty:** 2.00 **Required Qty:** 2.00

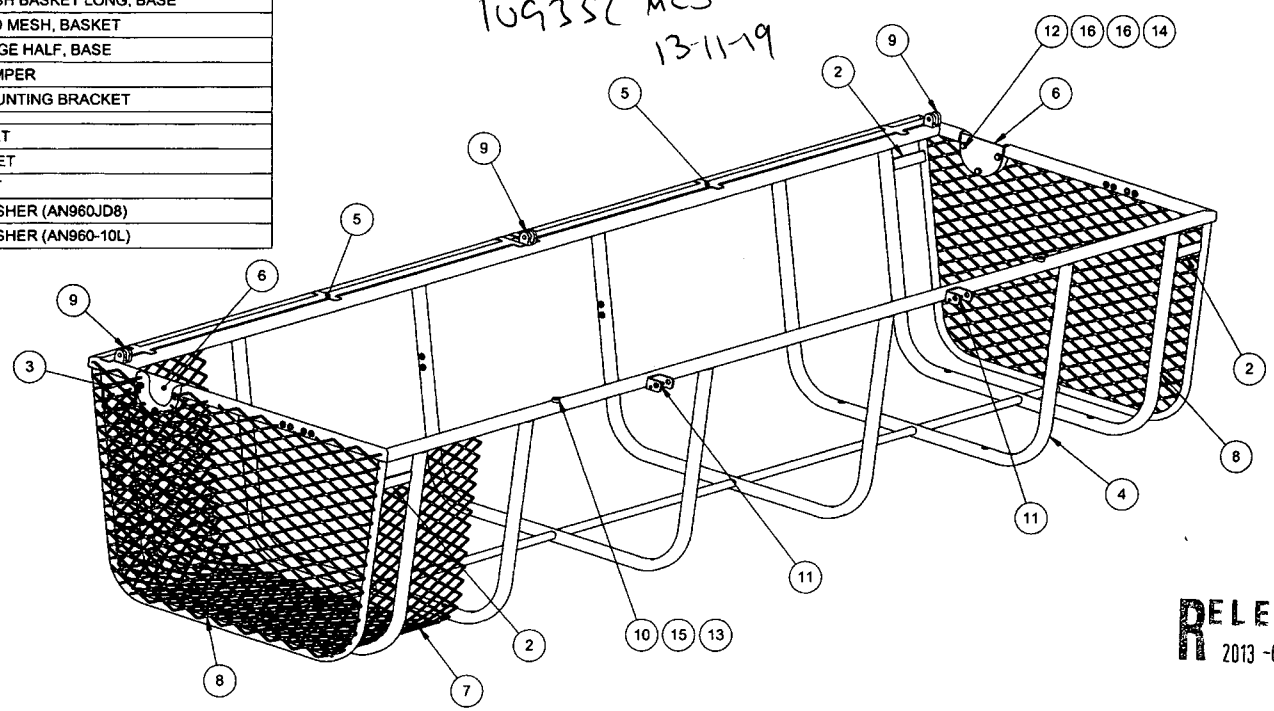
**Comments:** IPP REV:A 13.03.14 NEW ISSUE VERF:JLM IPP REV:B
13.06.21 DWG REV.B DD VERF:JFS

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| M304TS0.500W.049 | | Purchased | No | | | 100 | f | 1,263.261 | 1.673 | 4 | | | |
| *M304TS0.500W.049* | | | | | | | | | ** | CC 13-11-19 | | | |
| Square Tubing | | | | | | | | | | | | | |

| Location | Loc Qty | Loc Code | |
|---|---|---|---|
| WA006 | 1263.261527 | | |
| 118460 | 0.00001534 | | |
| 122938 | 0.266142 | | |
| 123565 | 0.005816 | | |
| 125062 | 472.91 | | (4) |
| 125502 | 246.32156 | | |
| M126080 | 67.287994 | | |
| M126581 | 476.47 | | |

| ITEM NO. | QTY. -041 | PART NUMBER | DESCRIPTION |
|---|---|---|---|
| 1 | X | D4785-041 | LONG BASKET BASE ASSY, LH/RH |
| | | | |
| 2 | 3 | D4793-1 | HANDLE PLATE |
| 3 | 1 | D4793-3 | WIDE HANDLE PLATE |
| 4 | 1 | D4785-101 | TUBULAR ASSEMBLY, LH/RH |
| 5 | 2 | D4672-1 | BLANKING PLATE |
| 6 | 2 | D4021-5 | BLANKING PLATE |
| 7 | 1 | D4020-1 | MESH BASKET LONG, BASE |
| 8 | 2 | D4020-11 | END MESH, BASKET |
| 9 | 3 | D4016-1 | HINGE HALF, BASE |
| 10 | 2 | D2931 | BUMPER |
| 11 | 2 | D2581 | MOUNTING BRACKET |
| | | | |
| 12 | 6 | AN3-10A | BOLT |
| 13 | 2 | MS20600AD4W3 | RIVET |
| 14 | 6 | MS21042L3 | NUT |
| 15 | 2 | NAS1149DN832J | WASHER (AN960JD8) |
| 16 | 12 | NAS1149F0332P | WASHER (AN960-10L) |

109332 MCJ
13-11-19




RELEASED
2013 -06- 20

## D4785-041 LONG BASKET BASE ASSY, LH/RH (B)

NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 50.42 lbs APPROX
8) INSTALL AFTER FINISH
9) MASK HOLES PRIOR TO POWDER COAT
10) WELD PER DART QSI 004

| REV. | DESCRIPTION | BY | DATE |
|---|---|---|---|
| B | REPLACE D3916-5 WITH D4785-117 (ZN B5-4, B4-4, B5-7); REVISE D4785-5 DIMENSION (ZN B5-5) | RF | 13.06.11 |
| A | NEW ISSUE | RF | 13.05.24 |

| | | | |
|---|---|---|---|
| DESIGN | RF | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | BC | DRAWING NO. D4785 | REV. B |
| MFG. APPR. | | | SHEET 1 OF 7 |
| APPROVED | | TITLE LONG BASKET BASE ASSY | SCALE NTS |
| DE APPR. | | | |
| DATE | 13.06.11 | | |

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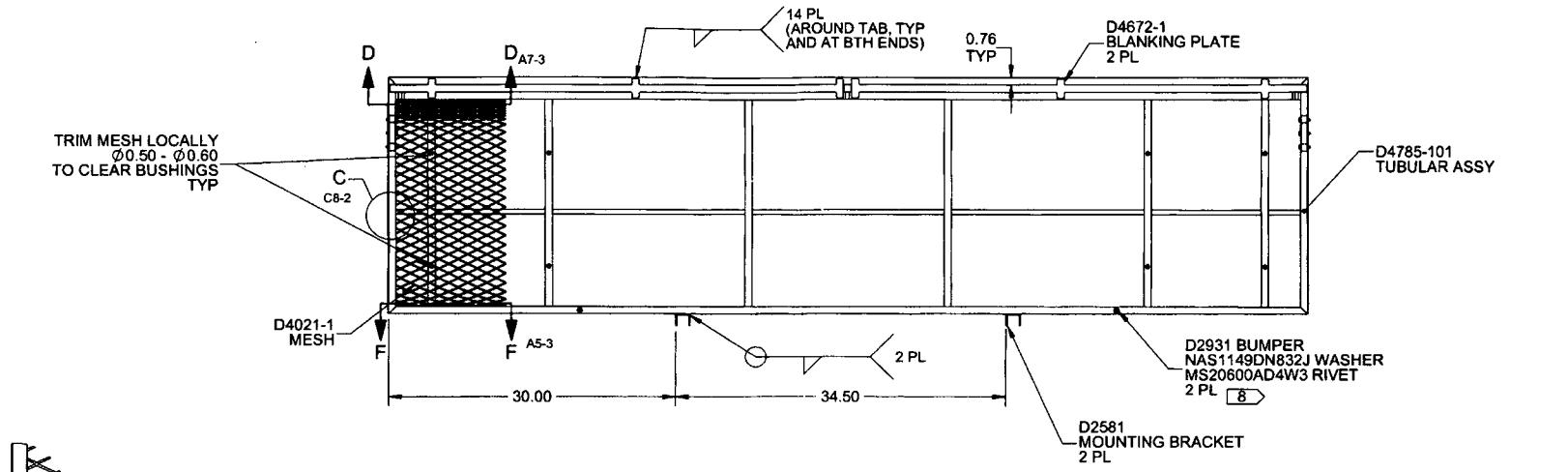
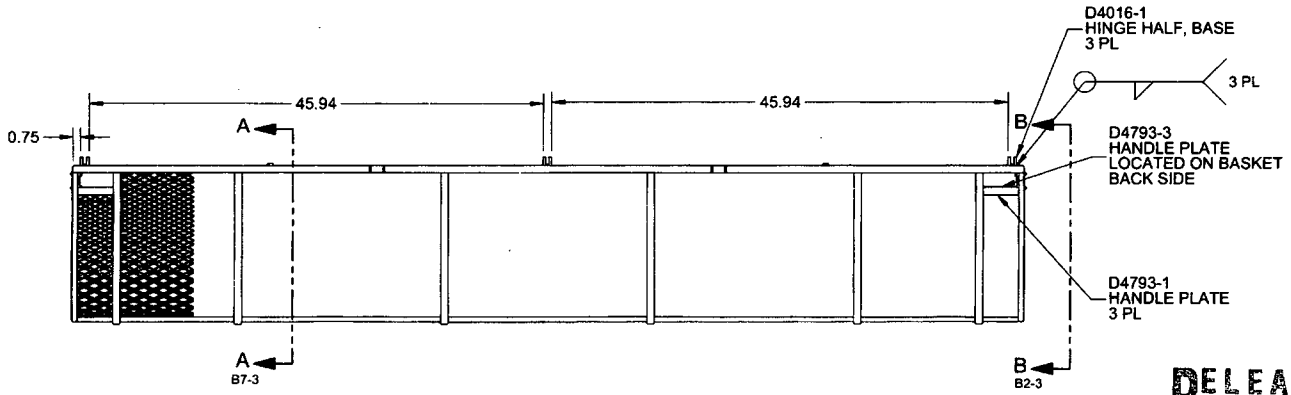


TACK WELD MESH
AT EVERY AVAILABLE
LOCATION

**DETAIL C** D7-2

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2013 -06- 20

**D4785-041 LONG BASKET BASE ASSY, LH/RH**
**(MESH SHOWN LOCALLY FOR CLARITY)**

| | | |
|---|---|---|
| DESIGN | RF | **DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA |
| DRAWN | RF | DRAWING NO. D4785 REV. B |
| CHECKED | BC | SHEET 2 OF 7 |
| MFG. APPR. | | TITLE LONG BASKET BASE ASSY SCALE NTS |
| APPROVED | | |
| DE APPR. | | |
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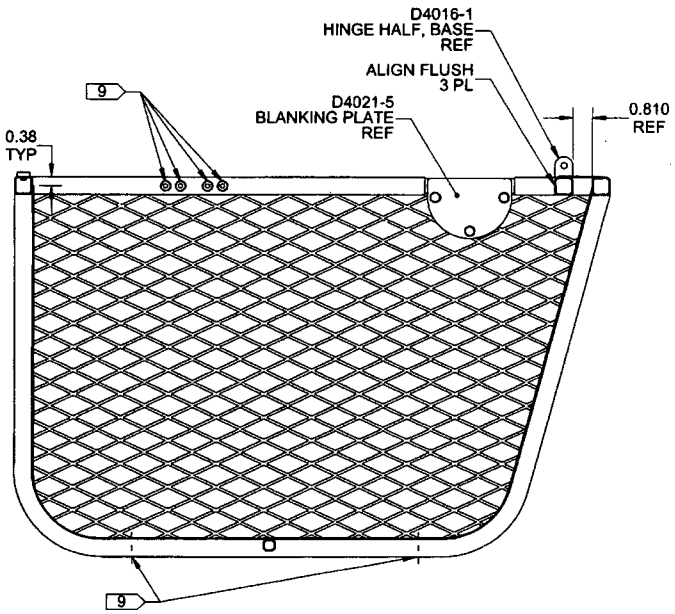
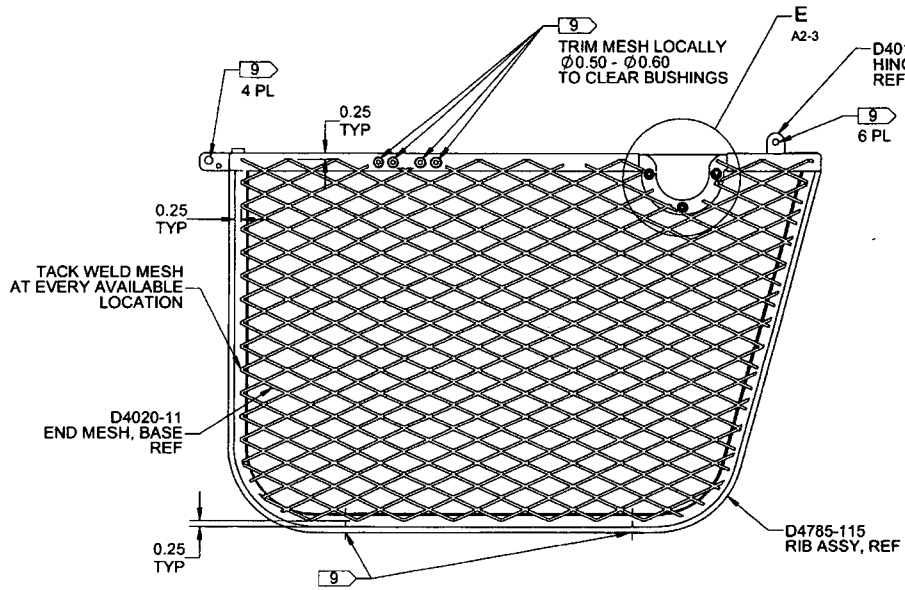
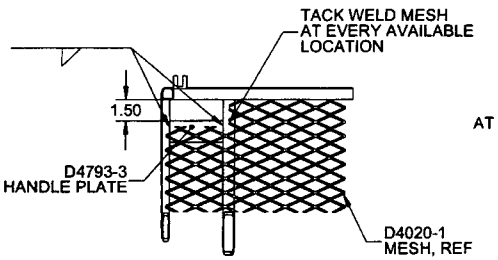


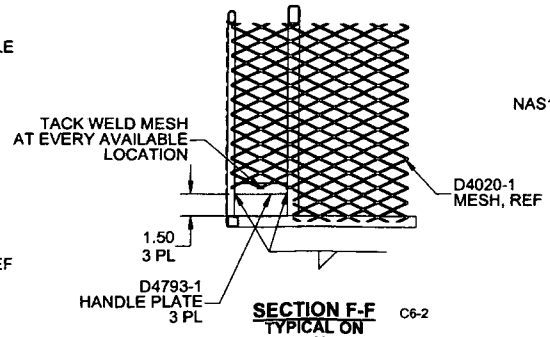

**SECTION A-A** B7-2



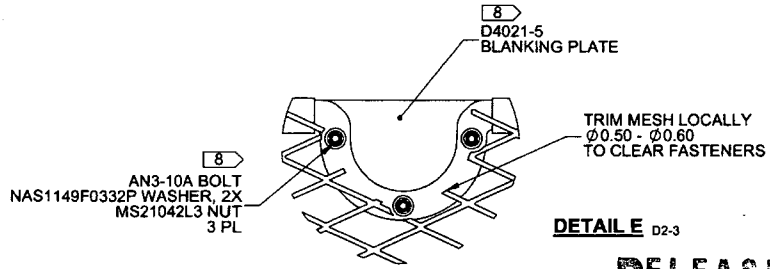

**SECTION VIEW B-B** A2-2




**SECTION D-D** D6-2




**SECTION F-F** C6-2
TYPICAL ON
3 PL




**DETAIL E** D2-3

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| | | |
|---|---|---|
| DESIGN | RF | **DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA |
| DRAWN | RF | |
| CHECKED | BC | DRAWING NO. D4785 REV. B |
| MFG. APPR. | | SHEET 3 OF 7 |
| APPROVED | | TITLE LONG BASKET BASE ASSY SCALE NTS |
| DE APPR. | | |
| DATE | 13.06.11 | |

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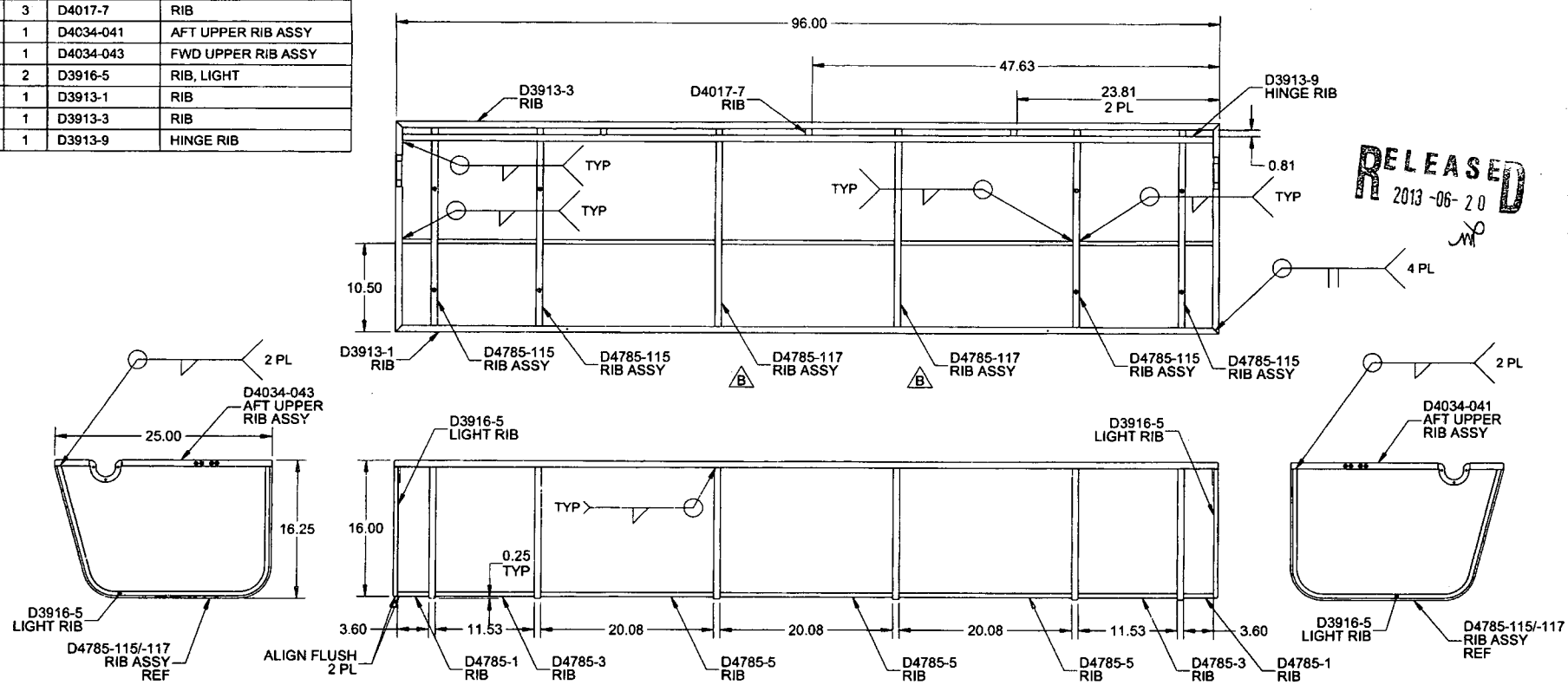
| ITEM NO. | QTY. -101 | PART NUMBER | DESCRIPTION |
|---|---|---|---|
| 1 | X | D4785-101 | TUBULAR ASSEMBLY |
| | | | |
| 2 | 2 | D4785-1 | RIB |
| 3 | 3 | D4785-5 | RIB |
| 4 | 4 | D4785-115 | RIB ASSEMBLY |
| 5 | 2 | D4785-117 | RIB ASSEMBLY |
| 6 | 2 | D4785-3 | RIB |
| 7 | 3 | D4017-7 | RIB |
| 8 | 1 | D4034-041 | AFT UPPER RIB ASSY |
| 9 | 1 | D4034-043 | FWD UPPER RIB ASSY |
| 10 | 2 | D3916-5 | RIB, LIGHT |
| 11 | 1 | D3913-1 | RIB |
| 12 | 1 | D3913-3 | RIB |
| 13 | 1 | D3913-9 | HINGE RIB |

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NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 28.65 lbs
8) WELD PER DART QSI 004

**D4785-101 TUBULAR ASSEMBLY, LH/RH**

| | | |
|---|---|---|
| DESIGN | RF | DART AEROSPACE LTD |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | SC | DRAWING NO. D4785 REV. B |
| MFG. APPR. | | SHEET 4 OF 7 |
| APPROVED | | TITLE LONG BASKET BASE ASSY SCALE NTS |
| DE APPR. | | |
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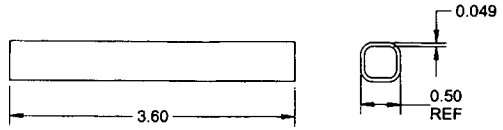
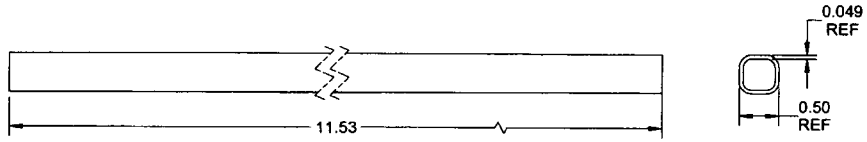
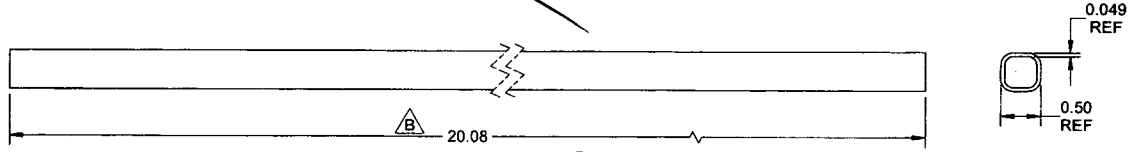



**D4785-1 RIB**




**D4785-3 RIB**




**D4785-5 RIB**

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2013 -06- 20

NOTES:
1) MATERIAL: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 x 0.50 x 0.049 WALL
PER ASTM A554 OR ASTM A269 MILL FINISH
REF DART SPEC. M304TS0.500W.049
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: SEE ASSEMBLED WEIGHTS

| | | |
|---|---|---|
| DESIGN | RF | **DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA |
| DRAWN | RF | |
| CHECKED | BC | DRAWING NO. D4785 REV. B SHEET 5 OF 7 |
| MFG. APPR. | | |
| APPROVED | | TITLE LONG BASKET BASE ASSY SCALE NTS |
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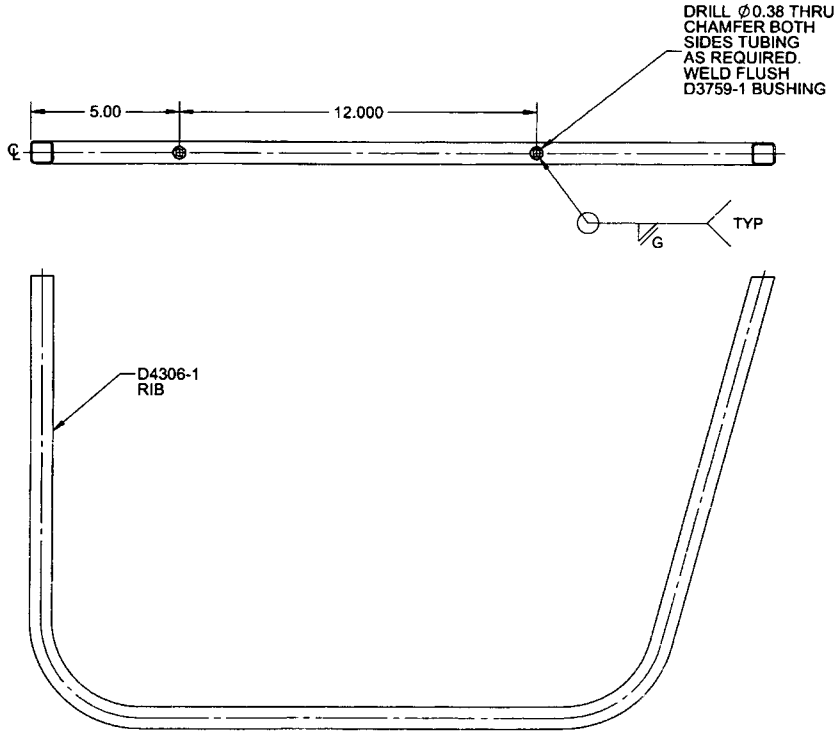
| ITEM NO. | QTY. -115 | PART NUMBER | DESCRIPTION |
|---|---|---|---|
| 1 | X | D4785-115 | RIB ASSEMBLY |
| | | | |
| 2 | 1 | D4306-1 | RIB |
| 3 | 2 | D3759-1 | BUSHING |




**D4785-115 RIB ASSEMBLY**
**MAKE FROM D4306-1 RIB**

RELEASED
2013 -06- 20

NOTES:
1) MATERIAL: D4306-1 RIB
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 1.80 lbs
8) WELD PER DART QSI 004

| | | |
|---|---|---|
| DESIGN | RF | **DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA |
| DRAWN | RF | |
| CHECKED | BC | DRAWING NO. D4785 REV. B |
| MFG. APPR. | | SHEET 6 OF 7 |
| APPROVED | | TITLE LONG BASKET BASE ASSY SCALE NTS |
| DE APPR. | | |
| DATE | 13.06.11 | |

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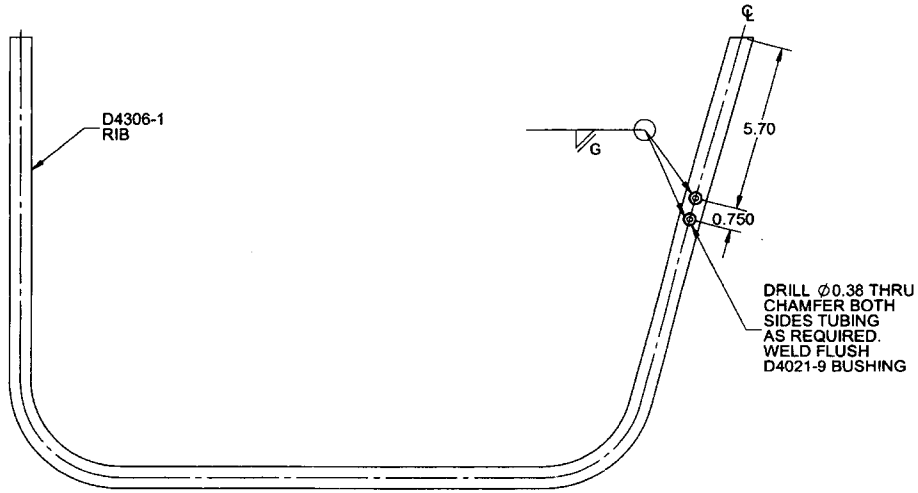
| ITEM NO. | QTY. -117 | PART NUMBER | DESCRIPTION |
|---|---|---|---|
| 1 | X | D4785-117 | RIB ASSEMBLY |
| | | | |
| 2 | 1 | D4306-1 | RIB |
| 3 | 2 | D4021-9 | BUSHING |




**D4785-117 RIB ASSEMBLY** (B)
**MAKE FROM D4306-1 RIB**

RELEASED
2013 -06- 20

NOTES:
1) MATERIAL: D4306-1 RIB
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 1.81 lbs
8) WELD PER DART QSI 004

| | |
|---|---|
| DESIGN | RF |
| DRAWN | RF |
| CHECKED | DC |
| MFG. APPR. | |
| APPROVED | |
| DE APPR. | |
| DATE | 13.06.11 |

**DART AEROSPACE LTD**
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D4785 REV. B
SHEET 7 OF 7
TITLE LONG BASKET BASE ASSY SCALE NTS

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